



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3560-2
Job Sheet 188646



Part No: D3560-2

Job Qty: 4 pcs

Part Name: Arm



Part Weight: 0 lbs

Job Created: 1/14/19

Due Date: 1/25/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP Rev:A New Issue 06-11-10 JLM use -042 IPP REV:B 13.06.03 PER DWG REV.F DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	1/25/19	1/25/19	0.00	0.29	Bandsaw - 1		DIP 19-01-23
110	HAAS 4 Axis - B4B	4 pcs	1/25/19	1/25/19	0.38	2.65	HAAS - 1 - B4B	mm	
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		DIP 19-01-23
120	QC 2	4 pcs	1/25/19	1/25/19	0.00	0.00	QC 2 - 1	mm	
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		



Container No: S147314



Part: D3560-2

Job No: 188646

Serial No/Batch: S147314

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/23/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
125	Conventional Mill - 1 - B4B	4 pcs	1/25/19	0.00 0.13	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
130	QC 8	4 pcs	1/25/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
210	Packaging 3-1 - Stock - B4B	4 pcs	1/25/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B

Entered: _____ Date: _____



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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
220 QC 21 - SA	4 pcs	1/25/19	0.00 0.00	QC 21 - SA - 21	DAS JAN 25 2019
				QC 21 - SA - 70	21
Part Op 100 - Cut blanks 16.750" long Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA694 Rev: _____ & Dwg D3560 Rev: _____ 120 - (QC2- Inspect parts off machine FAI/FAIB) 125 - (Manufacture as per dwg) 130 - (QC8- Inspect parts - second check) 210 - (Identify as per dwg & Stock Location: _____), LOCATION: WA003 220 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	5.5800 ft (1.395 ea)	100-Bandsaw - 1	8036667	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B0.500X05.000	6	38	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.507Inches + 0.000 - 0.001	0.507 0.506	0.5065	Diameter
2	Arm	0.196Inches + 0.005 - 0.001	0.201 0.195	0.197	Diameter
3	Arm	1.000Inches + 0.010 - 0.001	1.010 0.999	1.005	Diameter
4	Arm	0.500Inches ± 0.010	0.510 0.490	0.497	
5	Arm	0.250Inches ± 0.010	0.260 0.240	0.248	
6	Arm	0.275Inches ± 0.010	0.285 0.265	0.277	
7	Arm	0.188Inches ± 0.010	0.198 0.178	0.186	
8	Arm	2.000Inches ± 0.010	2.010 1.990	2.002	
9	Arm	1.700Inches ± 0.010	1.710 1.690	1.702	
10	Arm	0.385Inches ± 0.010	0.395 0.375	0.385	Diameter
11	Arm	100.000Degrees ± 0.500	100.500 99.500	100°	Angle
12	Arm	0.250Inches ± 0.010	0.260 0.240	0.248	Depth

DIP 19-01-23

Plex 1/14/19 8:11 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



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